

Work Order ID 68125

Wednesday, April 06, 2011 4:04:02 PM

Page 1

Item ID: D4165-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Rib

Start Date: 4/7/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-04-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4165

A

100

0.00



Waterjet

FLOW CNC Waterjet

2034.040

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

Quality Control

0.00

B11-4-7

B11-4-7

3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulox

x3

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x3 of 11-14-07

135

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 BL 11-14-7.

W/O:		WORK ORDER CHANGES						
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Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: 65

0.00



Packaging

Memo

0.00

Packaging

CMF
11-04-07

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/4/8

CMF
11-04-07

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, April 06, 2011 4:03:56 PM

Page 1

Work Order ID: 68125



Parent Item: D4165-5



Parent Item Name: Aft Rib

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	130.5000	0.58	1.221053			
2024-T3 .040 sheet													

1811-4-7

Location

Loc Qty

Loc Code

MAT022

130.5

112291

2.5

112331

64

113162

64

112331

(3)

Dart Aerospace Ltd

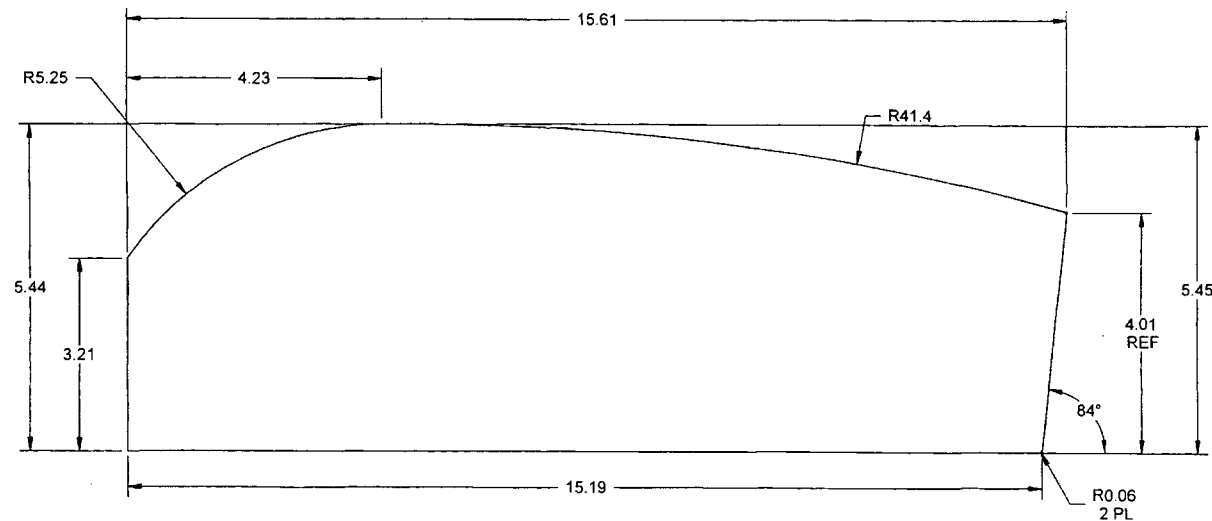
W/O:		WORK ORDER CHANGES						
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
D4165-5 AFT RIB
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-34)

68105

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4165	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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